

Date: Tuesday, 7/18/2006 3:00:38 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, OUTBOARD, LH, 206
Job Number	: 27965		
Estimate Number	: 10818		
P.O. Number	: NIA	Part Number	: D26651
This Issue	: 7/18/2006	S.O. No.	: NIA
Prsht Rev.	: NC	Drawing Number	: D2665 REV. C
First Issue	: NIA	Project Number	: N/A
Previous Run	: 27588	Drawing Revision	: C
	Type : MACHINED PARTS	Material	: NIA
Written By	: <u>JL/SA</u>	Due Date	: 8/10/2006
Checked & Approved By	: <u>06.07.19</u>	Qty:	12 Um: Each
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 2X6.25X7.875
Cut Size 2.0" x 6.25" x 7.88"
Grain Along Long 7.88 Length Batch no 1325346

SA 0607-30

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program batch number 0607-30
1-Inspect part number and batch number are programmed correctly
3-Fixturing Inspection last completed on 0607-30 by SA
4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
7- Deburr

JL/SA 0607.31

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

JL 06/08/02

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/SA 06.07.31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 26/8/14

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/18/2006 3:00:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 27965

Part Number: D26651

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Sn 06/08/07 X 17

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SC 06/08/09 (12)

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

R-m 06-08-10

(12)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

AL 06/08/11

(12)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST481

AL RB 06/08/11

(12)

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/08/14 (12)

Job Completion



C 06/08/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 27965
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. C	Page 1 of 1

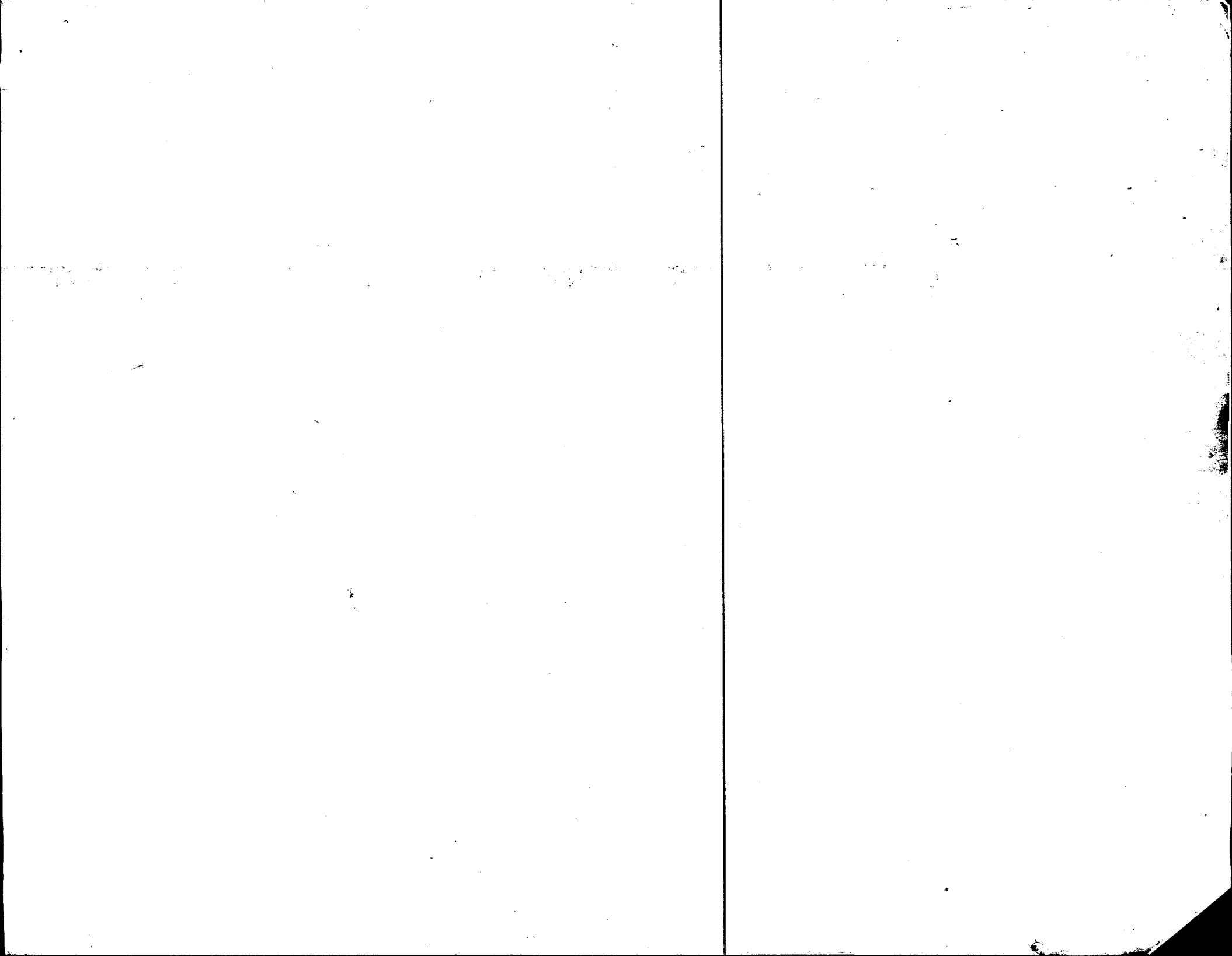
Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:


Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.119	.118	.117	.115		
B	0.100	0.140		.120	.120	.121	.121		
C	1.125	1.145		1.133	1.132	1.133	1.129		
D	0.615	0.685		.655	.655	.655	.655		
E	0.240	0.260		.251	.250	.250	.250		
F	1.313	1.343		1.323	1.323	1.324	1.324		
G	0.210	0.230		.220	.218	.218	.218		
H	0.100	0.180		.130	.130	.130	.130		
I	2.470	2.510		2.488	2.488	2.488	2.488		
J	1.565	1.585		1.573	1.570	1.572	1.568		
K	0.235	0.240		.238	.238	.237	.239		
L	0.100	0.120		.116	.119	.120	.120		
M	0.990	1.010		1.004	1.000	1.001	1.001		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		5.998	5.998	5.998	5.998		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.361		
V	0.787	0.807		.797	.797	.796	.796		
W	0.540	0.560		.548	.550	.549	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.921	.921	.922	.922		
AA	0.490	0.510		.499	.500	.500	.501		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD / J.L.
Date: 06.07.31 / 06/08/01

Audited by: En
Date: 06/08/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	



DART AEROSPACE LTD		Work Order:	27965
Description: 206 Saddle, Outboard, Left side		Part Number:	D2665-1
Inspection Dwg: D2665 Rev. C			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.117	.116	.111	.110		
B	0.100	0.140		.120	.121	.114	.114		
C	1.125	1.145		1.132	1.133	1.130	1.129		
D	0.615	0.685		.655	.655	.655	.655		
E	0.240	0.260		.251	.251	.246	.248		
F	1.313	1.343		1.325	1.325	1.322	1.324		
G	0.210	0.230		.218	.220	.211	.212		
H	0.100	0.180		.130	.130	.130	.130		
I	2.470	2.510		2.488	2.488	2.488	2.488		
J	1.565	1.585		1.570	1.571	1.568	1.567		
K	0.235	0.240		.239	.238	.238	.238		
L	0.100	0.120		.114	.113	.112	.111		
M	0.990	1.010		1.000	1.000	1.000	1.001		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		5.998	5.998	5.998	5.998		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.796	.797	.797		
W	0.540	0.560		.550	.550	.551	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.922	.922	.922	.922		
AA	0.490	0.510		.500	.500	.500	.499		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SL
Date:	06/08/01

Audited by:	CP
Date:	06/08/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27965
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

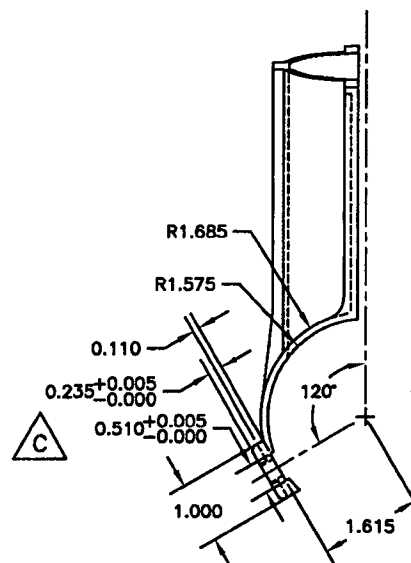
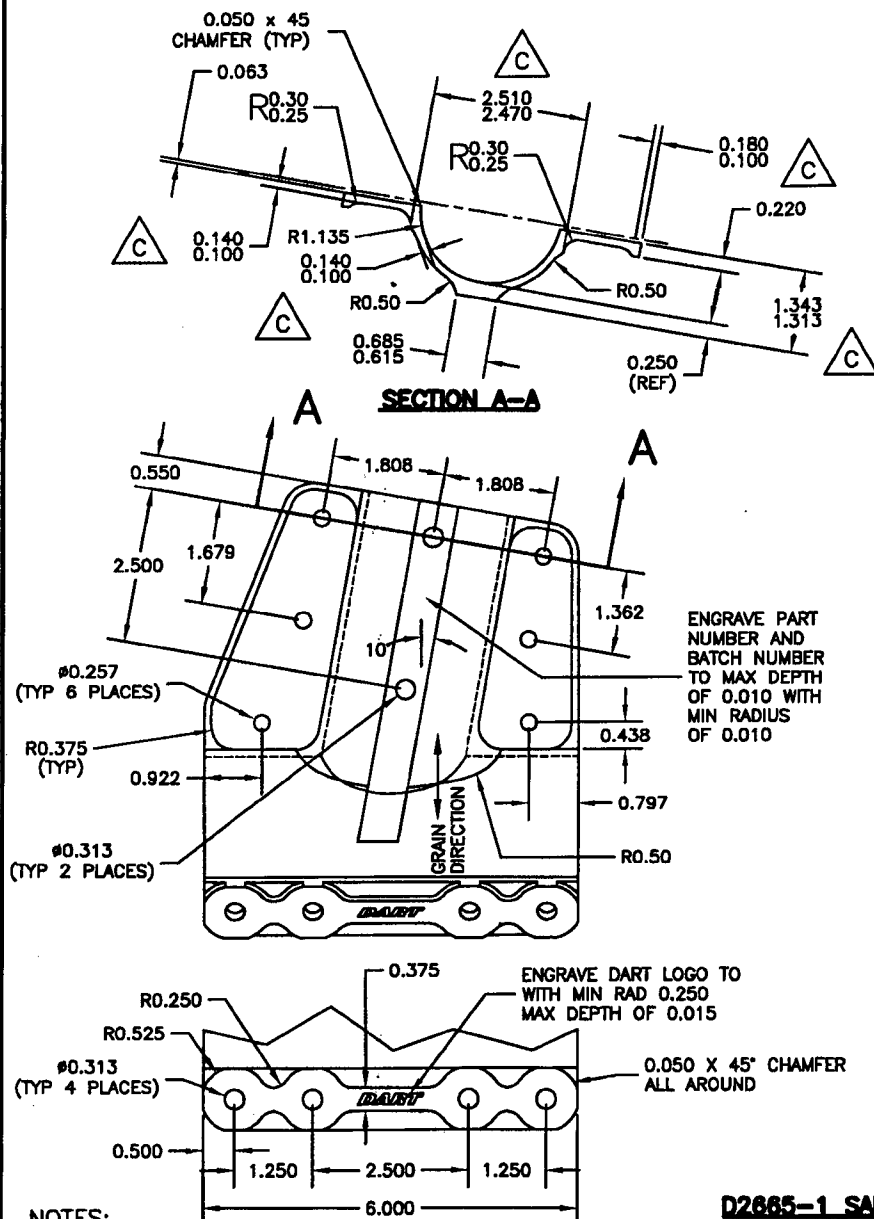
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.107	.107	.107	.112		
B	0.100	0.140		.120	.119	.120	.118		
C	1.125	1.145		1.130	1.130	1.128	1.136		
D	0.615	0.685		.655	.655	.655	.655		
E	0.240	0.260		.250	.248	.250	.243		
F	1.313	1.343		1.322	1.318	1.318	1.317		
G	0.210	0.230		.213	.211	.212	.213		
H	0.100	0.180		.130	.130	.130	.130		
I	2.470	2.510		2.488	2.488	2.488	2.488		
J	1.565	1.585		1.568	1.568	1.566	1.572		
K	0.235	0.240		.238	.239	.238	.238		
L	0.100	0.120		.112	.110	.112	.115		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		5.998	5.998	5.998	5.998		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.317	.317	.317	.317		
T	2.495	2.505		2.499	2.499	2.500	2.499		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.796	.796	.797		
W	0.540	0.560		.549	.550	.551	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.922	.922	.922	.922		
AA	0.490	0.510		.500	.500	.500	.501		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JL	Audited by: En
Date: 06/08/02	Date: 06/08/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
	C.B.	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2665	SHEET 1 OF 1
DATE		TITLE	SCALE
06.05.29		SADDLE FWD OUTSIDE HIGH	1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	

RELEASED
6.6.28**NOTES:**

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

D2665-1 SADDLE FWD OUTSIDE HIGH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27965

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